

17/09

Date: Tuesday, 9/11/2007 10:56:50 AM
 User: Chantal Lavoie

Process Sheet

Customer :				Drawing Name : DOUBLER
Job Number :	34545			
Estimate Number :	12959			
P.O. Number :				
This Issue :	9/11/2007	S.O. No. :		
Prsht Rev. :	NC			
First Issue :	/ /	Type :	SMALL /MED FAB	
Previous Run :	33721			
Written By :	<u>W</u>			
Checked & Approved By :				
Comment :	Est Rev:A	New Issue	07-07-20 JLM	Verified By:EC

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S050	2024-T3 .050 sheet	
		Comment: Qty.: 0.1747 sf(s)/Unit Total: 0.6989 sf(s) 2024-T3 .050 sheet Batch: <u>M105646</u>	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3642 Dwg Rev: <u>A</u> HB 07-09-19 Prog Rev: <u>A</u>	(4)
		2-Deburr if necessary HB 07-09-19	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		HB 07-09-19	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	5 07-09-19
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	(A) 07-09-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 9/11/2007 10:56:50 AM
User: Chantal Lavoie

Process Sheet

Customer:

Drawing Name: DOUBLER

Job Number: 34545

Part Number: D36421

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

En 3/08/20 (46)

7.0 PACKAGING 1.

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock
Location: *7/10/15 (Y1)*

ENGINEERING

APPROVAL

07.10.15

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.10.16 KJ

Job Completion



En 3/08/16

POSITIVE RECALL

EFFECTIVE 07.09.11 AUTH C

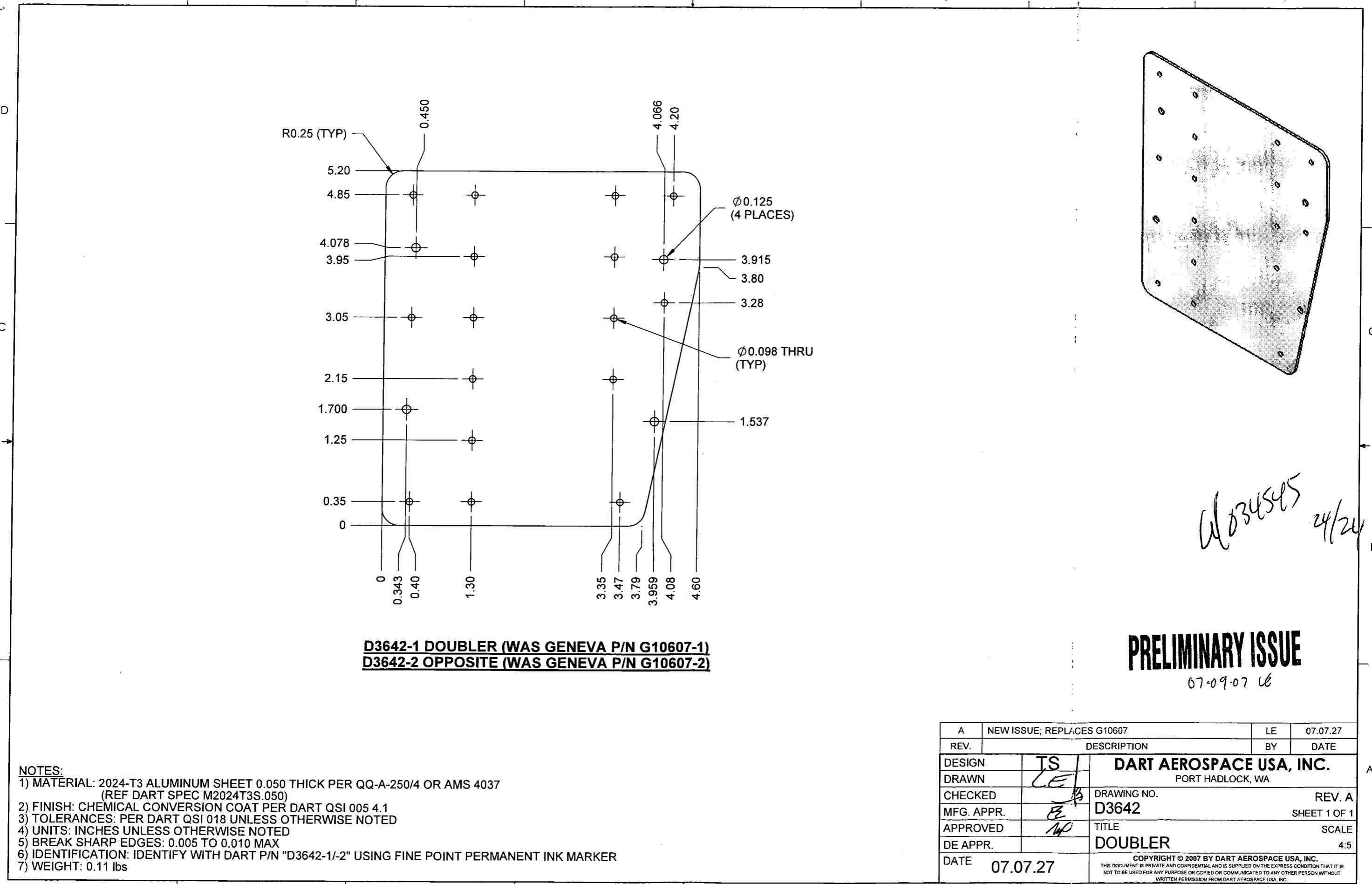
RELEASED US DATE 07.10.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DART AEROSPACE LTD	Work Order:	34545
Description: Doubler	Part Number:	D3642-1
Inspection Dwg: D3642 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .125	.005 - .001	.125				
Ø .098	.004 - .001	.098				
5.20	+/- .030	5.20				
4.85	+/- .030	4.85				
4.078	+/- .010	4.078				
3.95	+/- .030	3.95				
3.05	+/- .030	3.05				
2.15	+/- .030	2.15				
1.700	+/- .010	1.700				
1.25	+/- .030	1.25				
.35	+/- .030	.35				
.450	+/- .010	.450				
.343	+/- .010	.343				
.40	+/- .030	.40				
1.30	+/- .030	1.30				
3.35	+/- .030	3.35				
3.47	+/- .030	3.47				
3.79	+/- .030	3.79				
3.959	+/- .010	3.959				
4.08	+/- .030	4.08				
4.60	+/- .030	4.60				
4.066	+/- .010	4.066				
4.20	+/- .030	4.20				

Measured by:	BS	Audited by:	GR	Prototype Approval:	VE
Date:	07-09-19	Date:	07/09/19	Date:	07.09.19

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



DART AEROSPACE LTD	Work Order:	34545
Description: Double	Part Number:	D 3642-1
Inspection Dwg: D 3642 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

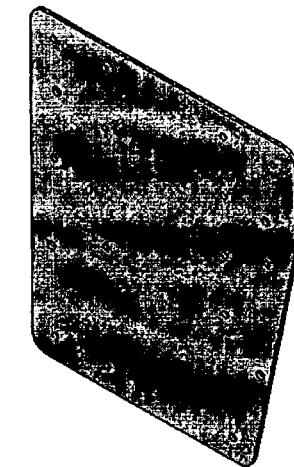
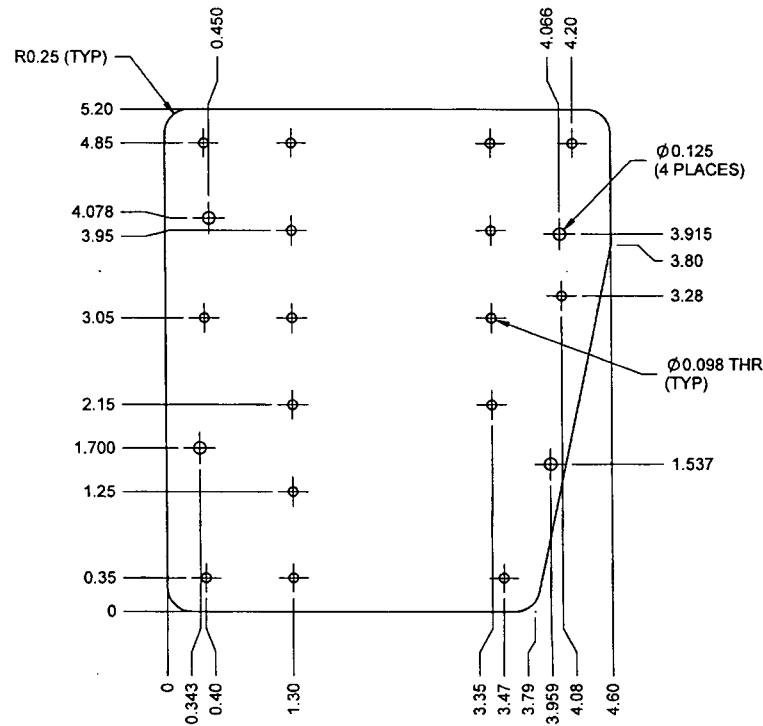
X First Article Prototype

Measured by:	RB	Audited by:	SN	Prototype Approval:	VE
Date:	07-09-19	Date:	2/09/19	Date:	07.09.19

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



8 7 6 5 4 3 2



REFERENCE

**D3642-1 DOUBLER (WAS GENEVA P/N G10607-1)
D3642-2 OPPOSITE (WAS GENEVA P/N G10607-2)**

RELEASED
07-29-2014

NOTES:
1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037
(REF DART SPEC M2024T3S.050)

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH PART P/N "D"

7) WEIGHT: 0.11 lbs

7) WEIGHT: 0.11 lbs

8

A	NEW ISSUE: REPLACES G10607		LE	07.07.27
REV.	DESCRIPTION		BY	DATE
DESIGN	TS	DART AEROSPACE USA, INC.		
DRAWN	<i>CE</i>	PORT HADLOCK, WA		
CHECKED	<i>b</i>	DRAWING NO.	REV. A	
MFG. APPR.	<i>RE</i>	D3642	SHEET 1 OF 1	
APPROVED	<i>MP</i>	TITLE	SCALE	
DE APPR.	<i>SH</i>	DOUBLER	4:5	
DATE	07.07.27		COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE PROPERTY OF DART AEROSPACE AND IS SUPPLIED UNDER THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN WHOLE OR IN PART BY OTHER PERSONS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	